

**METHOD OF MANUFACTURING CONSOLIDATED CELLULOSIC
PANELS WITH CONTOURED SURFACES AND
VARIABLE BASIS WEIGHT**

ABSTRACT OF THE DISCLOSURE

5 A method and system for manufacturing a consolidated cellulosic article
having first and second surfaces of a desired contour, a uniform density and variable
caliper and basis weight are disclosed. The method and system employ a primary
press having first and second similarly contoured platens to consolidate a mat of
cellulosic material and a binding agent to a softboard having first level of density with
10 first and second opposed sides of similar contour. A removal tool is then employed to
remove cellulosic material from one or both of the first and second sides in a planar
fashion. The resulting mat is then compressed a second time by a secondary press
having first and second platens corresponding in shape to a higher density level while
maintaining a substantially uniform caliper and basis weight.